

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010153**Date Inspected:** 17-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shen fu you**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

FCAW welding of weld joint 1G-010 located on PCMK SEG049* of 9AW welder is identified as 066673.ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-223(2)1T-2.

SAW welding of weld joint 1G-018 located on PCMK SEG071A of 11DW welder is identified as 045265.ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2C-S-2.

Witnessed Weld joint fit-up of splice weld SEG071A-007 dimension and tack weld checked with ZPMC QC Mr. Xu tao, to comply with the WPS-B-T-2231-B-U2-F.

SMAW welding of weld joint 2F-004 located on PCMK SSD13-PP72 of 9AW welder is identified as 066478. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2112-FCM-1.

FCAW welding of weld joint 3G-034 located on PCMK SEG051B of 9BW welder is identified as 202122.ZPMC

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QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 1G-001 located on PCMK SEG049A of 9AW welder is identified as 066401.ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231T-1 & WPS-B-T-2231-B-U2-F.

This Quality Assurance (QA) Inspector observed that a base metal distortion repair was performed on 6AW Deck panel DP273,DP245,DP219,DP155 in way of deck panel splice weld No. SEG027*-006,034,004,033. Approximately 250mm x 100mm of SMAW filler material was deposited around the splice weld. This base metal distortion repair was performed without the approval of the Engineer. For further information please see the Incident report,
040120F4_TL-15_B255_10-17-09_6AW_Base_Metal_Distortion Repair

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

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| Inspected By: | Kumar,Chadra | Quality Assurance Inspector |
| Reviewed By: | Patterson,Rodney | QA Reviewer |
